

Date: Monday, 19/01/2009 2:06:07 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: WEARPLATE
<b>Job Number</b>	: 44894		
<b>Estimate Number</b>	: 10673		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2975
<b>This Issue</b>	: 19/01/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2975 REV A
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 41443	<b>Drawing Revision</b>	: A
	<b>Type</b> : SMALL /MED FAB	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 10/02/2009
<b>Checked &amp; Approved By</b>	: <u>JUD 09.01.20</u>	<b>Qty:</b>	6
<b>Comment</b>	: Est: C 02.10.23 Re-format KJ	<b>Um:</b>	Each
	Est Rev:D Now on Waterjet 06-11-21 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M1010S16GA	1010/1025 sheet 16GA
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**Comment:** Qty.: 0.2896 sf(s)/Unit Total : 1.7375 sf(s)

1010/1025/A21/6aA SHEET .063"

Batch: 105706 HB 9-2-11

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D2975

Dwg Rev: A

Prog Rev: A

HB 9-2-11

2-Deburr if necessary

HB 9-2-11

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-2-11

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

Sort 12 (12)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Deburr if necessary

Form as per dwg D2975 using DT8261 & DT8326

SB 09/02/19 (12)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 44894

Part Number: D2975

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-02-19 (12)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8210 as per Dwg D2975 & QSI 004

Qty Description Batch

A/R 7560 Hardcoat Rod M109560

FL 9-2-21

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/02/23 (X12)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 11:00am

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:30am

9/11 09-02-23

(X12)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 09/02/23 (12)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 498

88

09/02/23 (X12)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/24

Job Completion



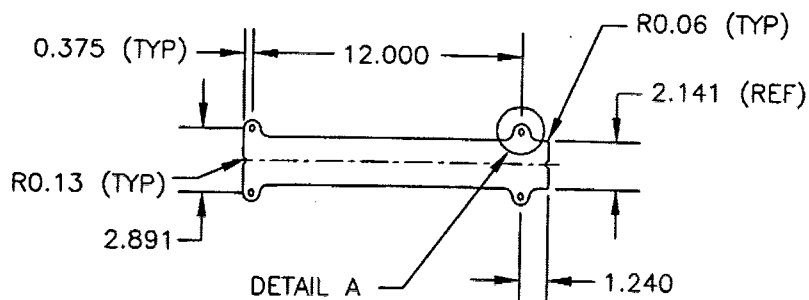
MF 09-02-23



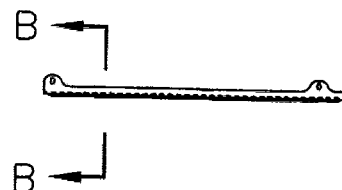


DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2975	REV. A SHEET 1 OF 1
DATE 00.03.10		TITLE WEARPLATE	SCALE 1:8
A	00.03.10	NEW ISSUE	

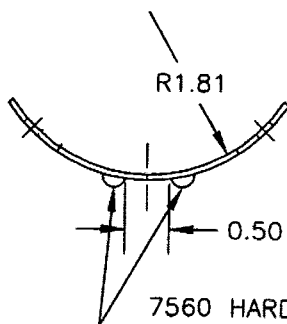
### FLAT PATTERN



### BENDING DETAIL

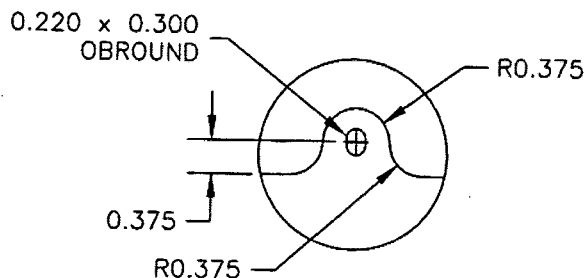


### SECTION B-B SCALE 2:5



7560 HARDCOAT WELDS TO  
WITHIN 0.25 OF WEARSHOE  
ENDS 0.063 TO 0.125 THICK

### DETAIL A SCALE 2:5



**RELEASED**  
00.05.11 *[Signature]*

BREAK ALL SHARP EDGES 0.010 TO 0.020  
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL  
16 GAUGE (0.063 THICK)  
FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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